



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D212-664-201
Job Sheet 168063-C



Part No: D212-664-201

Job Qty: 1 ea

Part Name: Aft Crosstube - High



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/9/17

Job Tracking No:

Due Date: 11/15/17

Created By: Linda Lacelle

Type: Stock

Description:

Customer: Rotorcraft Support Inc (CROTO01)

16425 Hart Street Van Nuys, CA, 91406 USA ph:(818) 997-7667 fx:(818) 997-1513.

Note: DWG DSI9563 REV B, D212-664-241 REV E IPP Rev:E 04.02.16 Reformat K/DS IPP Rev:F 06-03-29
Remove Coments on Pick List JLM IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H 08-05-22 up date Qty of
rubber cushion DD ver:EC IPP REV:I 14.05.27 AS PER ECN14-570 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	1 Ea	11/14/17	11/14/17	0.00	0.00	Start Up Crosstubes		DPZ
110	Packaging	1 pcs	11/14/17	11/14/17	0.00	0.00	Packaging1		DPZ
120	CNC Bend Crosstubes	1 pcs	11/14/17	11/14/17	0.00	4.44	CNC Bend Crosstube		GP
130	QC	1 pcs	11/14/17	11/14/17	0.00	0.00	QC15		38
140	Crosstubes	1 pcs	11/14/17	11/14/17	0.00	4.99	Crosstube		DPZ
150	HandFXtube	1 pcs	11/14/17	11/14/17	0.00	1.25	HandFinish5		DPZ
160	QC	1 pcs	11/14/17	11/14/17	0.00	0.00	QC7		PD 18-01-22
170	QC	1 pcs	11/14/17	11/14/17	0.00	0.00	QC5		PD 10-01-22
180	Outsource	1 pcs	11/14/17	11/14/17	0.00	0.00	Outsource2		Chm
190	Packaging	1 pcs	11/14/17	11/14/17	0.00	0.00	Packaging2		Chm
200	QC	1 pcs	11/14/17	11/14/17	0.00	0.00	QC5		38
210	SprayPaint	1 pcs	11/14/17	11/14/17	0.00	1.47	Spray Paint		✓ AS 18-1-27
220	QC	1 pcs	11/14/17	11/14/17	0.00	0.00	QC14		PD 18-02-29
230	Crosstubes	1 pcs	11/15/17	11/15/17	0.00	1.47	Crosstube		✓ AS 18-1-27
240	QC	1 pcs	11/15/17	11/15/17	0.00	0.00	QC5		38
250	Packaging	1 pcs	11/15/17	11/15/17	0.00	0.00	Packaging1		18 FEB 01 2018
260	QC	1 pcs	11/15/17	11/15/17	0.00	0.00	QC4		SmrS
265	DC	1 pcs	11/15/17	11/15/17	0.00	0.00	DC		
270	Packaging	1 pcs	11/15/17	11/15/17	0.00	0.00	Packaging3		SmrS
280	QC21-FG	1 Ea	11/15/17	11/15/17	0.00	0.00	QC21		DAS 21 FEB 05 2018

Part Op 120 - ***VERF SET-UP BEFORE BENDING BY: _____ *** Bend tube as per Dwg D212-664-241 using
Descriptions: CNC bender program 212-aft

140 - 1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550, DT8551, drill table DT8577 and locate tower holes #8 as per QSI0010. 2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241 4- ***WEAR LATEX GLOVES HANDLING CROSSTUBE.*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

150 - ***IMMEDIATELY AFTER GRINDING***

180 - ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: _____

190 - ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.***

200 - ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Inspect for damage & ensure results are as per

D212-664-201/168063-C/5033347



Art CrossTube - High

PART NO:
Original NO:
Revision:
Operation:
Change No:

D212-664-201
Start up Operation
CHG006

Operation 01/18/18
Job No: 168063-C

Dart Aerospace Ltd.
1270 Aberdeen Street
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Dwg D212-664-241

210 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

220 - Then, Wrap in plastic bag to protect from scratches

230 - *****LAY DOWN CROSSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MEASURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-241 and QSI 015 A/R Proseal 890 Batch: 138208 EXP: 5/18

PROSEAL CURE TIME 72 HOURS: Start: 18-1-27 Finish: 18-1-30 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg D212-664-241. ***Torque all clamps to 80-100 IN-LBS.***

240 - ***RE-CHECK TORQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

260 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

265 - Photocopy bluefile and create labels as per PPP D212-664-201 CHG006

270 - Identify and pack for shipping as per PPP D212-664-201 Location : FG098

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D212-664-201TRN	1	8	0	0
250-Packaging	AN6-40A	4	82	0	0
	AN6-41A	2	56	0	0
	D3428-1	1	19	0	0
	MS21042L6	6	226	0	0
	NAS1149D0663J	18	645	0	0

Part Specifications

Specifications could not be found.

Plex 11/10/17 12:29 PM dart.lacelle.linda

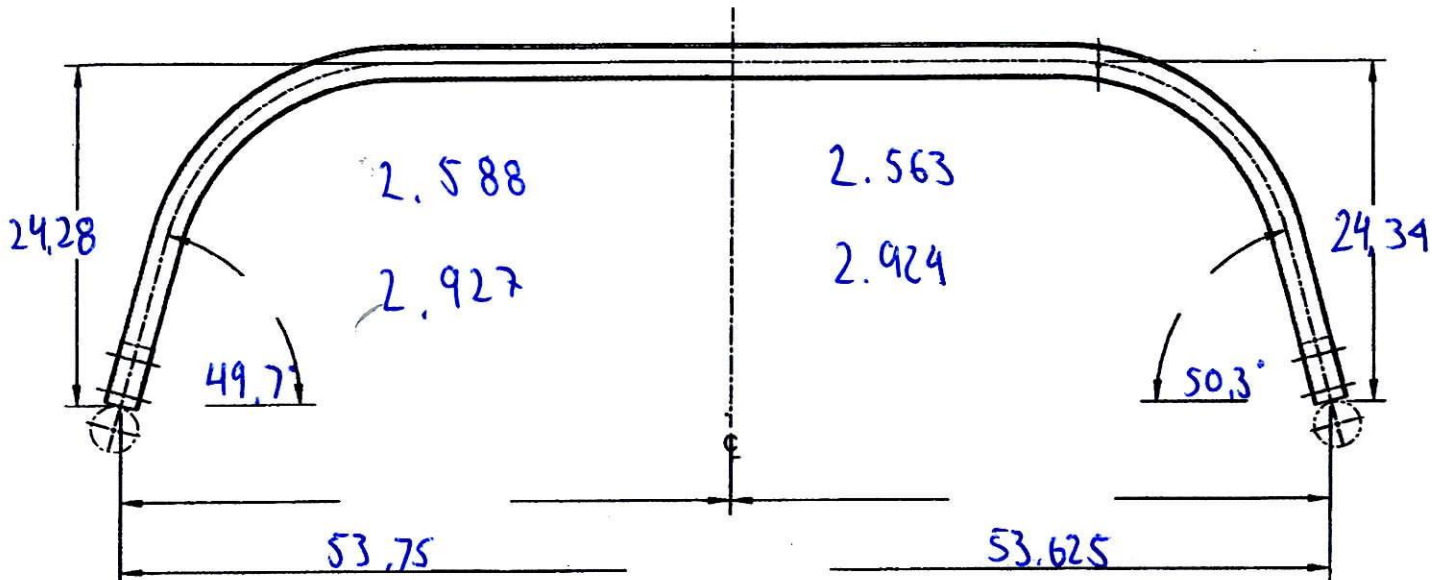
D2940-1 159566① 161793①

D3595-063-530 5007091②

MS21920-28 M137963-168④

DART AEROSPACE LTD		Work Order: 168063-C
Description: Crosstube High Aft (205/212)		Part Number: D212-664-201
Inspection Dwg: D212-664-241 Rev: E		Page 1 of 1

Required Dimension	Min	Max
Height	24.17	24.43
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70
Bending Passes	5	--
Crushing	--	7.2%



	Side A	Side B
Bending Passes	10	10
Crushing	6.1%	6.6%
Comments		

QC15 Inspection	DAS 38 2-88
Date	JAN 17 2018

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. C	KJ/JLM	
C	10.04.01	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	
E	14.07.08	Crushing percentage revised	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038831

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO038831
PO Date: 1/22/18
Due Date: 1/25/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items											
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price	
1	167186	D4883-7	End Fitting Outsource process - NDT per QSI038 4.1 Issue P/O: _____ LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required.	Firmed	1/25/18	10 pcs	0 pcs	10 pcs	\$55.1429/pcs	\$551.43	
2	167164	D4885-3	End Fitting ISSUE P/O : _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417	Firmed	1/25/18	8 pcs	0 pcs	8 pcs	\$55.1429/pcs	\$441.14	
3	169544	D4464-041	Fuel Tank Assembly ISSUE P/O : _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	1/25/18	1 pcs	0 pcs	1 pcs	\$55.1429/pcs	\$55.14	
4	168063-C	D212-664-201	Aft Crosstube - High ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	1/25/18	1 pcs	0 pcs	1 pcs	\$55.1429/pcs	\$55.14	
5	170235	D212-664-201	Aft Crosstube - High ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	1/25/18	1 pcs	0 pcs	1 pcs	\$55.1429/pcs	\$55.14	
Grand Total:										\$1,158.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report

18/01/27 *md*

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO34719	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO038831
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

2 AFT CROSSTUBES, P/N# D212-664-201, J/S# 168063-C, 170235 ✓

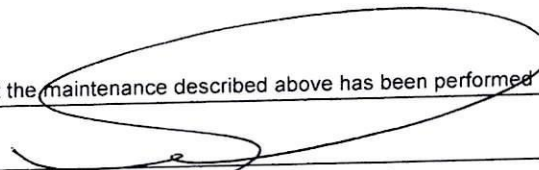
1 FUEL TANK ASSY, P/N# D4464-041, J/S# 169544 ✓

8 END FITTING, P/N# D4885-3, J/S# 167164 ✓

10 END FITTING, P/N# D4883-7, J/S# 167186 ✓

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923, DEV. MPO11715 , UV LIGHT M-20142						JAN 23 2018	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: JAN 23 2018
Name: RAFIK MELIKIAN		



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Master Unit 000339

Tel (613) 632-5200

Containers on Master Unit 000339				
Serial No	Part No	Customer Part No	Status	Quantity
S037726	AN6-40A		Allocated	4
S037725	AN6-41A		Allocated	2
S037724	D3428-1		Allocated	1
S037723	MS21042L6		Allocated	6
S037722	NAS1149D0663J		Allocated	18